

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68404

Tuesday, April 12, 2011 3:37:53 PM



Page 2

Item ID:	D4368-043	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Aft Wearplate Assembly					
Start Date:	4/12/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	4/15/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	- Inspector to PA1 Dwg only Saw 11/04/19						
130 Brake NC Brake NC	Form as per dwg Memo	0.00 0.00	Sp 11/04/20						
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	- Inspector to PA1 Dwg only Saw 11/04/20						

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NOTE: Date & initial all entries



Work Order ID 68404



Tuesday, April 12, 2011 3:37:53 PM



Page 3

Item ID: D4368-043 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Aft Wearplate Assembly
Start Date: 4/12/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 4/15/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Large Fab	Memo 1- on D4369-3, fill cut outs with hardcoat welding rod as per dwg D4368 **DT9756** 2059 B Hardcoat Welding Rod BATCH#: _____ 2-weld D4369-3 to wearplate by positioning holes together as per dwg D4368 304 S.S. Welding Rod BATCH #: _____ 3-Transfer drill holes in bar	0.00 0.00							
160  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							

POSITIVE RECALLEFFECTIVE 11.04.13 AUTH u

RELEASED _____ DATE _____

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NOTE: Date & initial all entries

Work Order ID 68404

Tuesday, April 12, 2011 3:37:53 PM



Page 4

Item ID: D4368-043

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Aft Wearplate Assembly

Start Date: 4/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

180

0.00



Small Fab

Memo

0.00

Small Fab

1- After finish, coat entire top (concave) surface as per note 10 on sheet 2 dwg
D4368.

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES						
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Work Order ID 68404

Tuesday, April 12, 2011 3:37:53 PM



Page 5

Item ID:	D4368-043	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Aft Wearplate Assembly					
Start Date:	4/12/2011	Start Qty:	1.00			
Required Date:	4/15/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

✓ 02382

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 12, 2011 3:38:00 PM

Work Order ID: 68404



Parent Item: D4368-043



Parent Item Name: Aft Wearplate Assembly

Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.12 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA

Purchased

No

100

sf

204.0000

2.179

2.293684



B11-4-19

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT020

204

111743

1

112178

4

113062

18

116135

48

116604

37

116979

96

116135

①

D4369-3

Manufactured

No

150

Each

0.0000

1

1



Bar

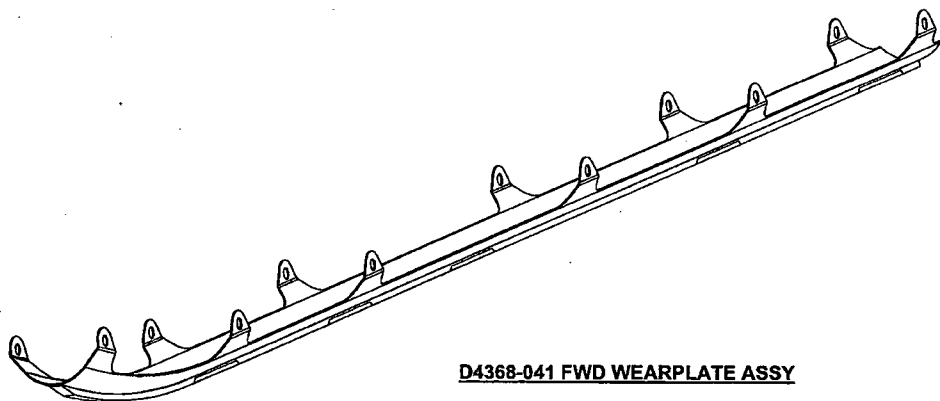
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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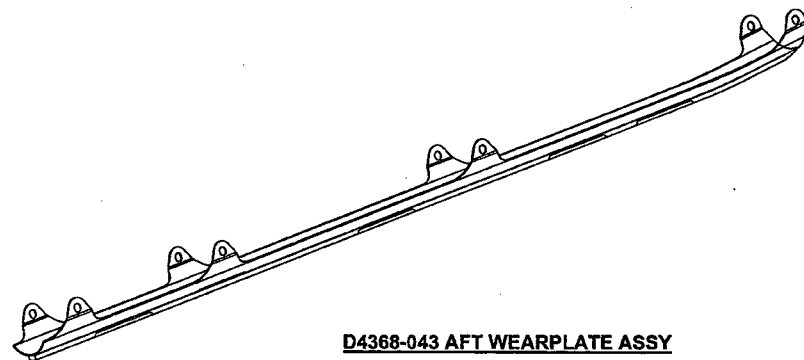
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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D4368-041 FWD WEARPLATE ASSY



D4368-043 AFT WEARPLATE ASSY

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X		D4368-041	FWD WEARPLATE ASSY
		X	D4368-043	AFT WEARPLATE ASSY
1	1		D4368-1	PLATE
2		1	D4368-3	PLATE
3	1		D4369-1	BAR
4		1	D4369-3	BAR
5	A/R	A/R	2059B	HARDCOAT
6	A/R	A/R	ROCKGUARD 4714	SEALANT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 684104

2111-04-12

**PRELIMINARY
ISSUE**

PA1	NEW ISSUE	SC	11.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4368	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	11.03.24	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY OTHER MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

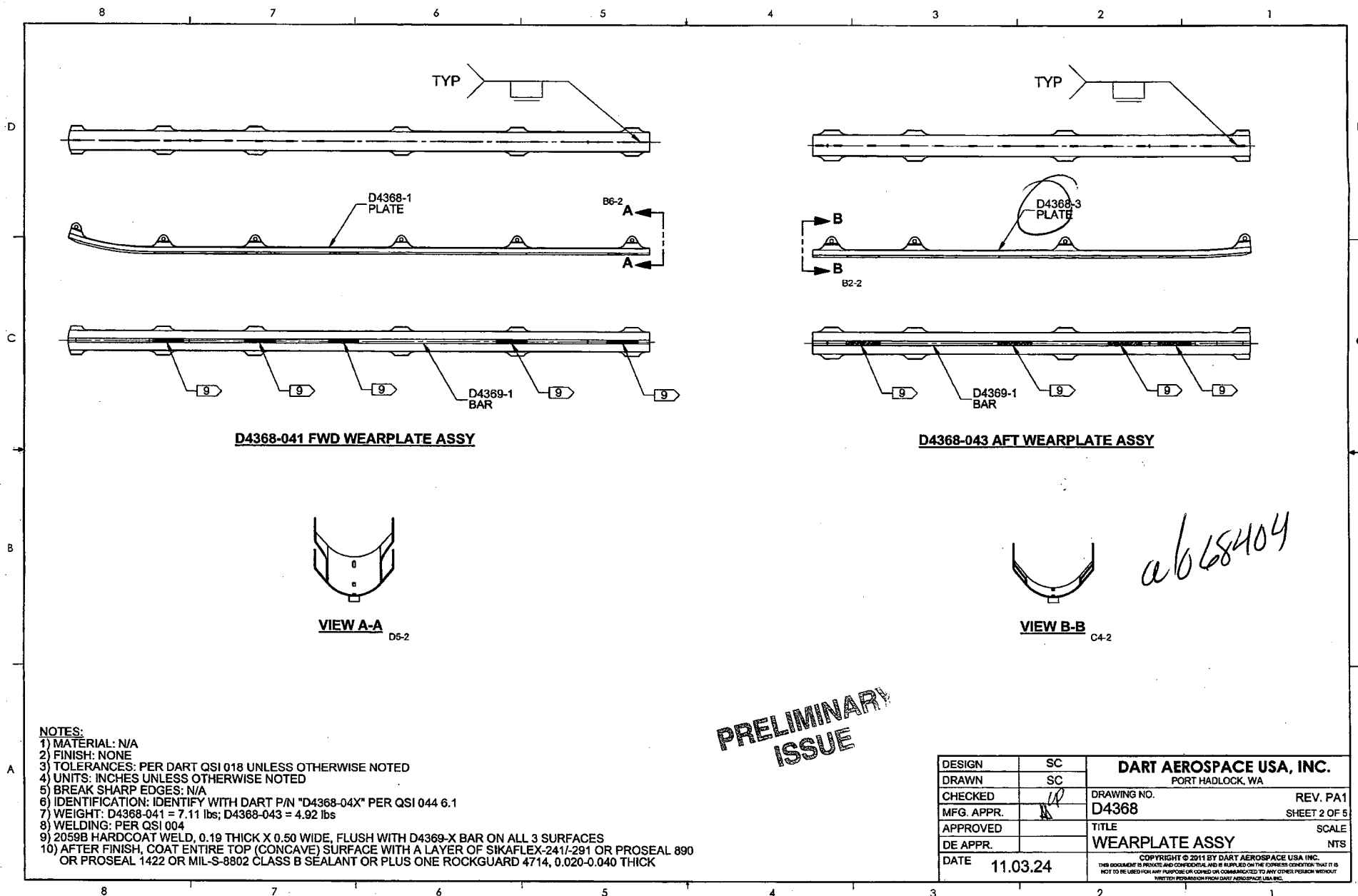
W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4368-04X" PER QSI 044 6.1
- 7) WEIGHT: D4368-041 = 7.11 lbs; D4368-043 = 4.92 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4369-X BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR PROSEAL 1422 OR MIL-S-8802 CLASS B SEALANT OR PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK

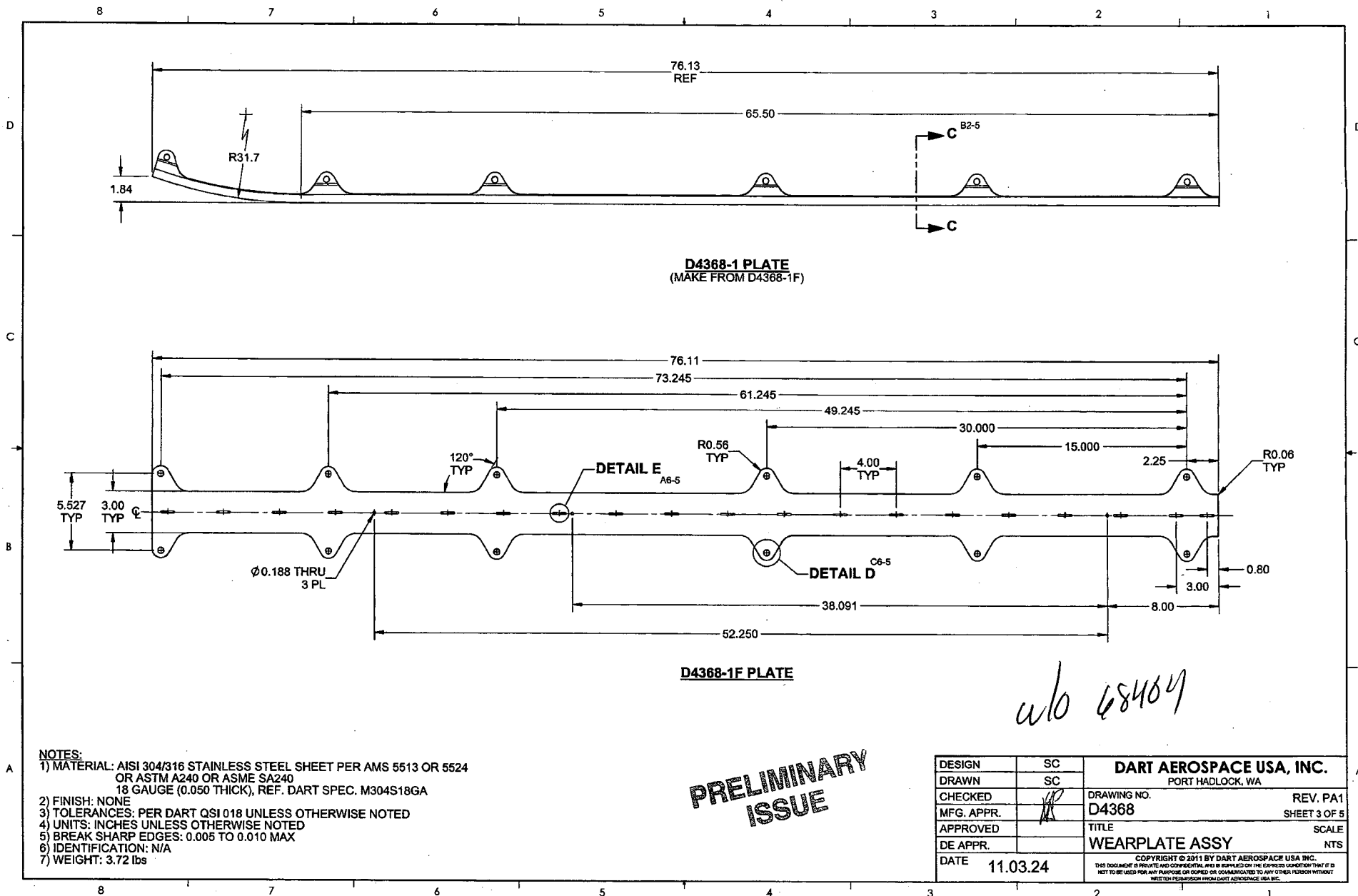
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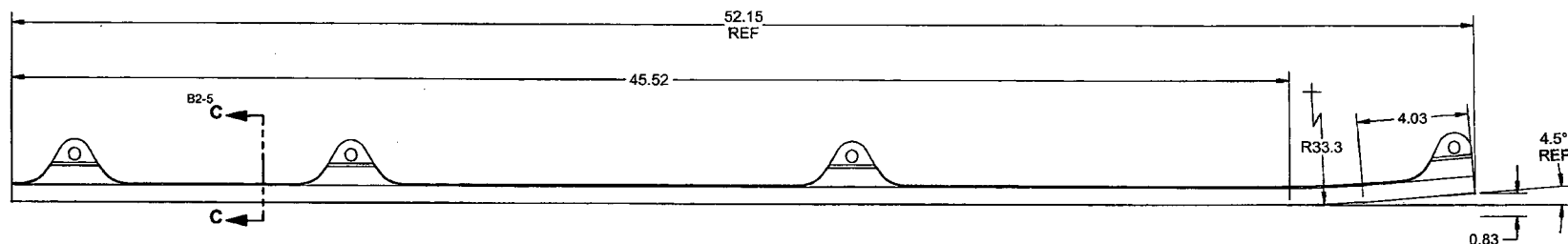
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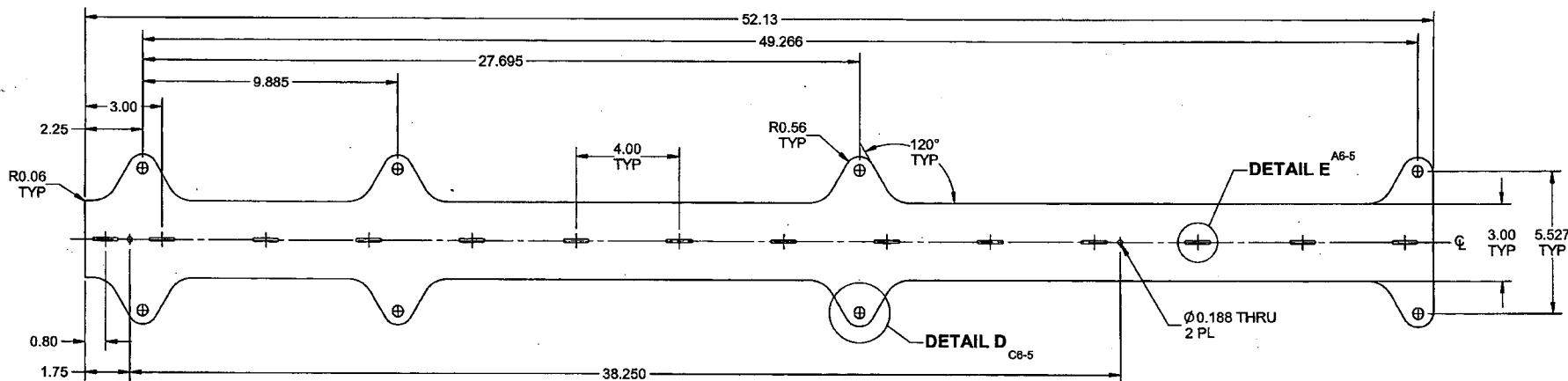
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4368-3 PLATE
(MAKE FROM D4368-3F)



D4368-3F PLATE

w/o 68404

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.53 lbs

**PRELIMINARY
ISSUE**

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. PA1
MFG. APPR.	JP	D4368	SHEET 4 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	11.03.24	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

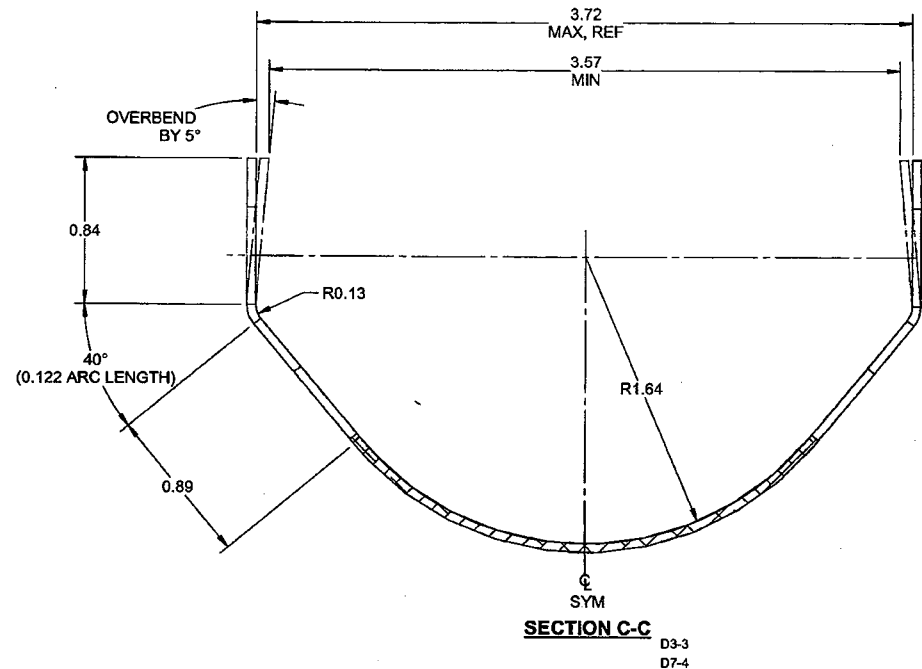
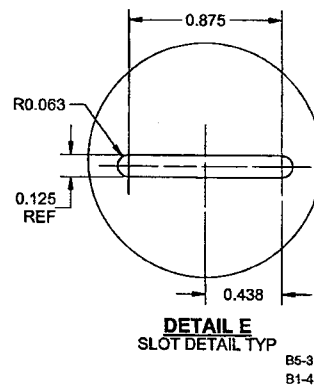
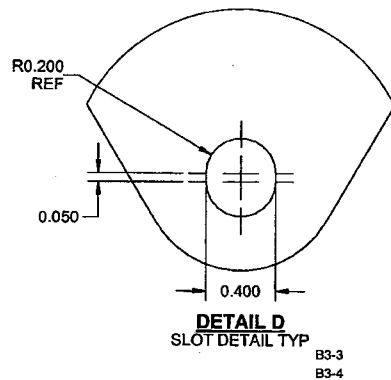
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also 45404

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APPROVED		TITLE	SCALE
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DART AEROSPACE LTD		Work Order: 68404
Description: AST WEAR PLATE ASSEMBLY		Part Number: D4368-043
Inspection Dwg: D4368-3, Rev: PA1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.400	$\pm .010$.408	✓		V HB02	
.125	$\pm .010$.131	✓		V	
.875	$\pm .010$.875	✓		V	
.80	$\pm .030$.800	✓		V	
1.75	$\pm .030$	1.753	✓		V	
38.250	$\pm .010$	38.250	✓		T	
5.525	$\pm .010$	5.525	✓		V	
3.00	$\pm .030$	3.007	✓		V	
Ø .188	$+ .005 - .001$.193	✓		V	
4.00	$\pm .030$	3.998	✓		V	
3.00	$\pm .030$	3.000	✓		V	
2.25	$\pm .030$	2.252	✓		V	
9.885	$\pm .010$	9.888	✓		T	
27.695	$\pm .010$	27.695	✓		T	
49.266	$\pm .010$	49.266	✓		T	
52.13	$\pm .030$	52.13	✓		T	
.050	$\pm .010$.048	✓		V	

Measured by: IB	Audited by: S	Prototype Approval:
Date: 11-4-19	Date: 11/04/19 to PA1 Dwg 01/19	Date:
Rev A	Date	Change
		New Issue
Revised by	Approved	
KJ/JLM		